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D2618

Job Sheet 166575



Part No: D2618

Job Qty: 100 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/13/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B1 IPP Rev:F Re-format 05-11-22 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea	10/13/17	0.00	0.00	Start up container	
100	Hardinge	100 pcs	10/13/17	0.13	9.31	Hardinge	
120	QC	100 pcs	10/13/17	0.00	0.00	QC8	
130	Packaging	100 pcs	10/13/17	0.00	0.00	Packaging3	
140	QC21-SA	100 Ea	10/13/17	0.00	0.00	QC21	

Part Op Descriptions: 100 - 1-Turn as per Folio FA195 & Dwg D2618.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MDELRLNR0.750	26	65	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	3.100inches ± 0.010	3.110 3.090		
2	Bushing	0.500inches + 0.000 - 0.010	0.500 0.490		
3	Bushing	0.313inches + 0.020 - 0.000	0.333 0.313		

Plex 10/11/17 3:01 PM Dart.lajeunesse.marie

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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W I P PART NO: D2618 Revision: Operation: Start up Operation Quantity: 100 Next Op: 100 Hardinge	OCT17	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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Root Cause		Job #: 166575 Mfg Date: 10/12/17		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No ☐ Op ☐ Off ☐ Sup ☐ Tra ☐ Use ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Bushing SERIAL NO S000452	Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	r Loss/Surge ☐ r Program ☐ ig Stock Pulled ☐ of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
OTHER : _____					